

Date: Thursday, 3/23/2006 3:52:19 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 26369	
Estimate Number : 10834	
P.O. Number : N/A	Part Number : D29332
This Issue : 3/23/2006 S.O. No. : N/A	Drawing Number : D2933 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 3/23/2006 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 26080	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 4/10/2006
Checked & Approved By : 06.03.24	Qty: 4 Um: Each
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: 24890

SD

06/04/22

4

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

SD 06.04.22

4

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

SD 06.04.22

4

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SD 06.04.22

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:52:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 26369

Part Number: D29332

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 06/04/25 x4

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.M. 06-04-26 (4)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M. 06-04-26 (4)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

06/04/27 (4)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST475

SB 06/04/27 (4)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/04/28 (4)

Job Completion



CY 06/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 26369
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. B	Page 1 of 1

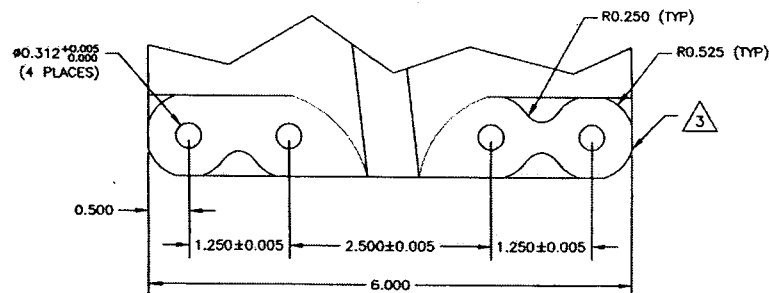
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.123	.122	.123		
B	0.100	0.140		.122	.124	.123	.122		
C	0.100	0.140		.126	.126	.122	.114		
D	0.210	0.230		.226	.227	.227	.226		
E	1.245	1.255		1.250	1.250	1.250	1.256		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.237					
N	0.100	0.140		.122	.123	.124	.124		
O	0.540	0.560		.550	.550	.549	.549		
P	0.490	0.510		.501	.502	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.497	2.497	2.498	2.495		
S	0.240	0.270		.254	.254	.252	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.636	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.134	1.134	1.135	1.136		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD
Date: 06.04.22

Audited by: En
Date: 06/04/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

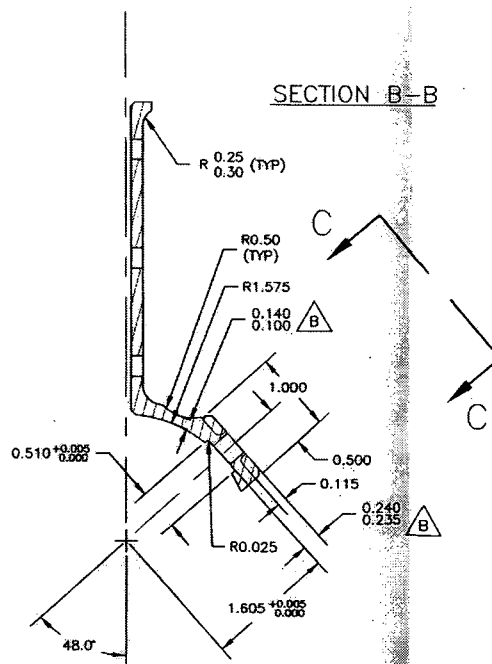


VIEW C-C

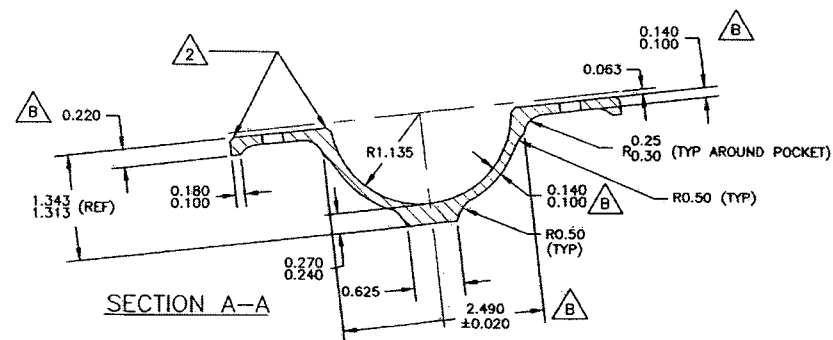
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI-018 UNLESS OTHERWISE NOTED.

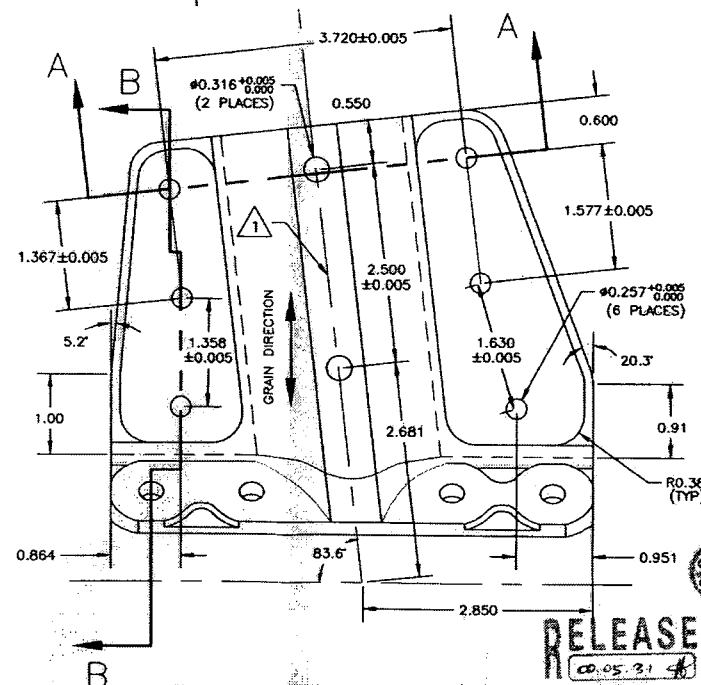
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



SECTION B-B



SECTION A-A



RELEASED
 00.05.29

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	00.05.29	TITLE SADDLE INSIDE
COPYRIGHT © 1989 BY DART AEROSPACE USA, INC.		REV. B SHEET 1 OF 1 SCALE 2:3

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NO. 26369
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

Date: Friday, 4/28/2006 7:09:08 AM

User: Chantal Lavoie

INVENTORY ITEMS PICKED
FOR SLIP NUMBER 2128

Project No. : N/A
Customer : Dart Helicopters Services
Part Number : D29332
Job Number : 26369

Drawing Number : D2933 REV B
Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Due Date : / /
Qty : 4
Slip # : 2128

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 D6101001 7075-T7351 2X6X6.25 Available 253.00	MAIN			24890		4.00	4.0000 Each